

26.508

Date: Thursday, 3/30/2006 8:32:36 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job Number	: 26425		
Estimate Number	: 10467		
P.O. Number	: <i>N/A</i>	Part Number	: D3391021
This Issue	: 3/30/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3391 REV D
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 25515	Drawing Revision	: D
		Material	: <i>N/A</i>
		Due Date	: 4/10/2006
Written By	: <i>See Comment Below</i>	Qty:	1 Um: Each
Checked & Approved By	: <i>06.03.30</i>		
Comment	: Est. A 05.09.13 New issue KJ/JLM Est. B 06.02.10 Dwg rev.D ecn 773 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	D6013047	SKIDTUBE MAT'L								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)</p> <p>SKIDTUBE MAT'L</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> <tr> <td>1</td><td>D6013-047</td><td>Extrusion</td><td><i>B23935 DP 06-4-9</i></td></tr> </table>			Qty	Part Number	Description	Batch	1	D6013-047	Extrusion	<i>B23935 DP 06-4-9</i>
Qty	Part Number	Description	Batch							
1	D6013-047	Extrusion	<i>B23935 DP 06-4-9</i>							
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1								
<p>Comment: LANDING GEAR RESOURCE 1</p> <p>Cut extrusion to 46.52 +0.010 -0.020 <i>mk 06/04/16</i></p>										
3.0	BENDING	BENDING MACHINE								
<p>Comment: No bender</p> <p>Bend as per Dwg D3391 Using Bend Prog 3391021 <i>DP 06-4-12</i></p>										
4.0	QC5	INSPECT WORK TO CURRENT STEP								
<p>Comment: INSPECT WORK TO CURRENT STEP</p>										
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1								
<p>Comment: HAAS CNC VERTICAL MACHINING #1</p> <p>1-Machine as per Folio FA590 Rev. <i>AA</i> & Dwg D3391 Rev. <i>D</i></p> <p>Identify as D3391-1</p> <p>2-Deburr <i>mk 06/04/16</i></p>										

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 8:32:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 26425

Part Number: D3391021

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/04/16

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/04/26

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

BE 06-04-27 (1)

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

BE 06-04-27 (1)

3-Open tow cap holes to .208" as per Dwg D3391

BE 06-04-27 (1)

4-Open Tow Ring hole to .640" as per Dwg D3391

BE 06-04-27 (1)

5-Drill wearplate holes as per Dwg D3391 Using Dt8217 & DT8878

BE 06-04-27 (1)

6--Deburr

BE 06-04-27 (1)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06 05 03 (1)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06-05-10 (1)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



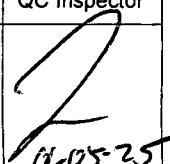
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/05/10 (1)

8.1 QC5 DP 06-5-2

9.1 QC3 DL 06/05/03 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-25	8 9	change already made.					 06-05-25

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 8:32:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 26425

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty	Part Number	Description	Batch
1	D3401-041	Tow Cap	B26590

13.0

AN3C4A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN3C4A	Bolt	M100651

14.0

NAS1330C3KB166



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Rivnut

Pick:

Qty	Part Number	Description	Batch
14	NAS1330C3KB166	Insert	M100732

DL 06-05-09

15.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3L	Washer	M100186

16.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

washer

M18822

DL 06/05/2009

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts and Tow Cap as per Dwg D3391

Identify as D3391-021

DL 06/05/10

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 26425

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8821

ml 06 05 10 (1)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *N/A*

DL 06/05/24 (1)

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/05/25 (1)

Job Completion



U 06-05-25

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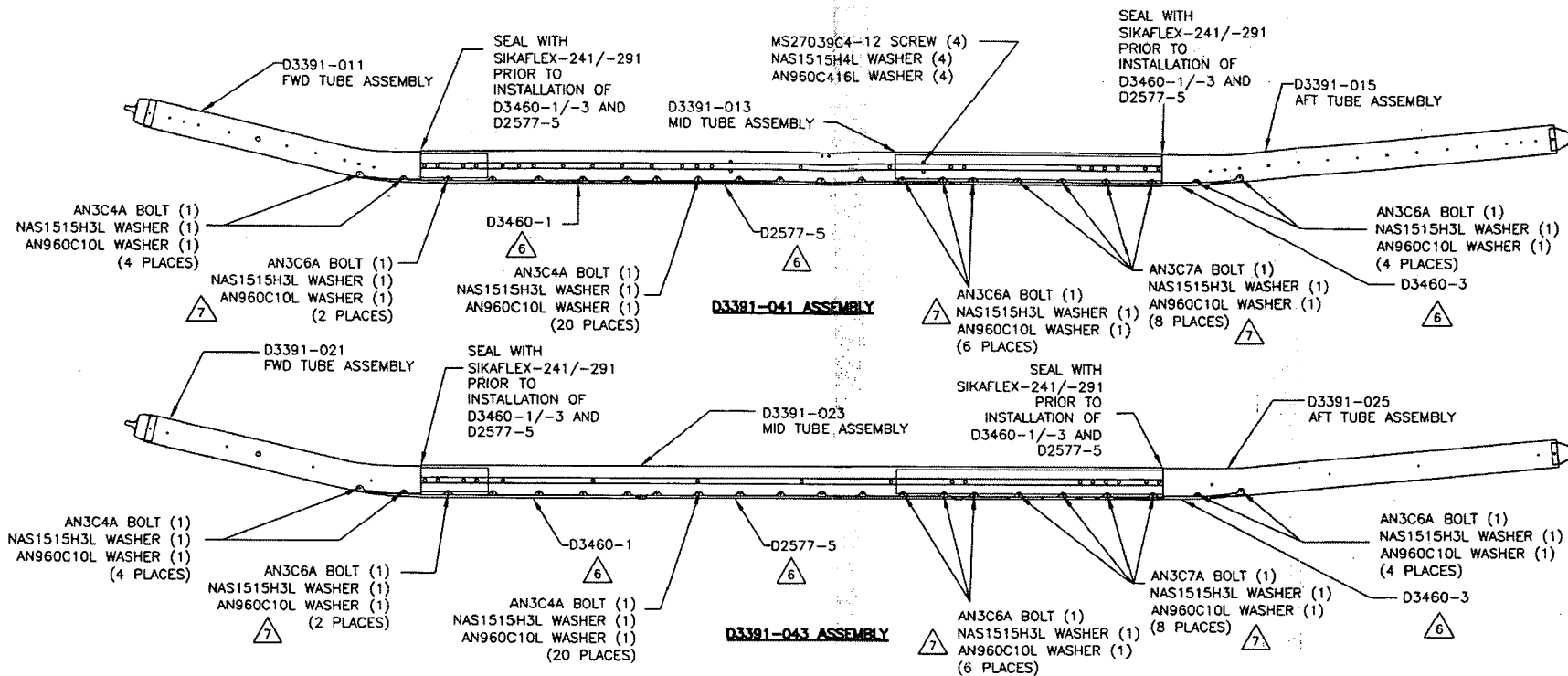
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.
- C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- DO NOT TORQUE, HAND TIGHTEN ONLY

△

RELEASED

06-01-27

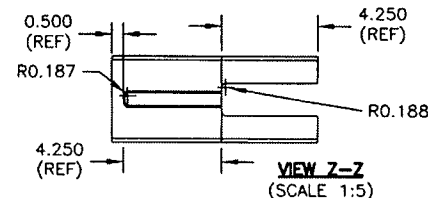
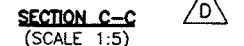
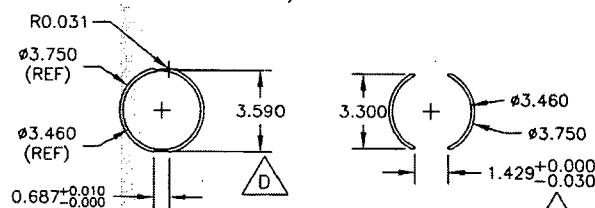
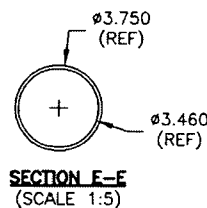
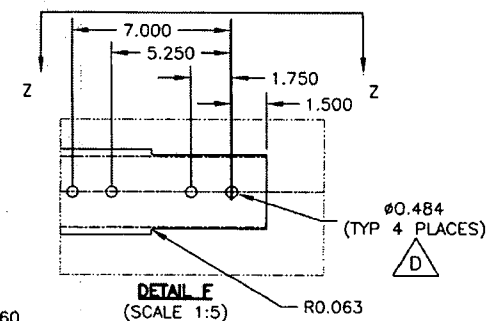
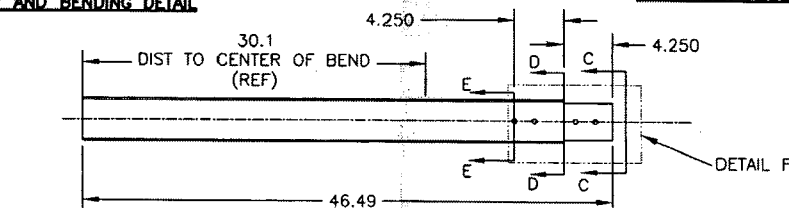
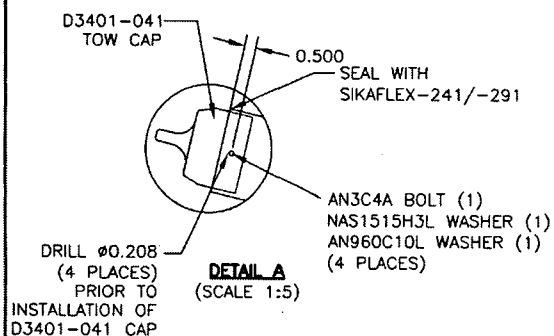
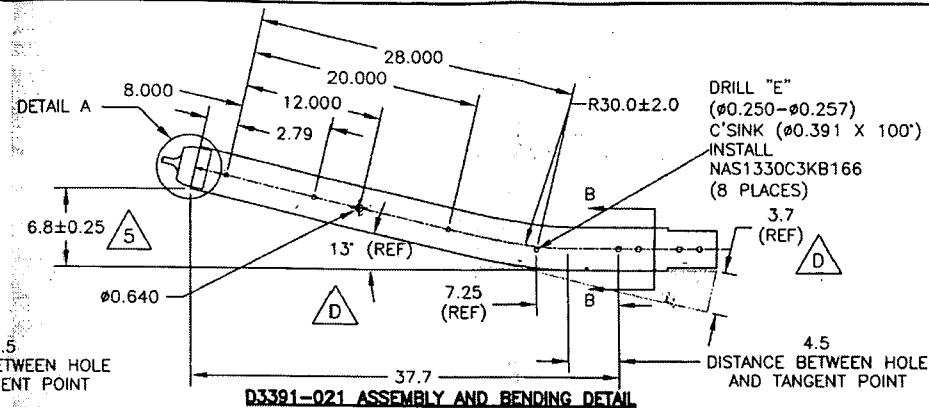
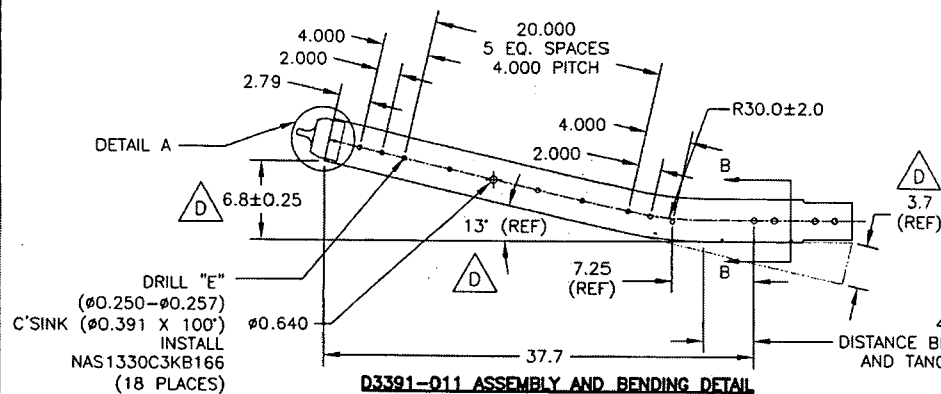
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	06.01.23	DRAWING NO. D3391
		TITLE 412 FLOAT SKIDTUBE
		REV. 0 SHEET 1 OF 5 SCALE NTS

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WORK ORDER
NO. 26425



D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

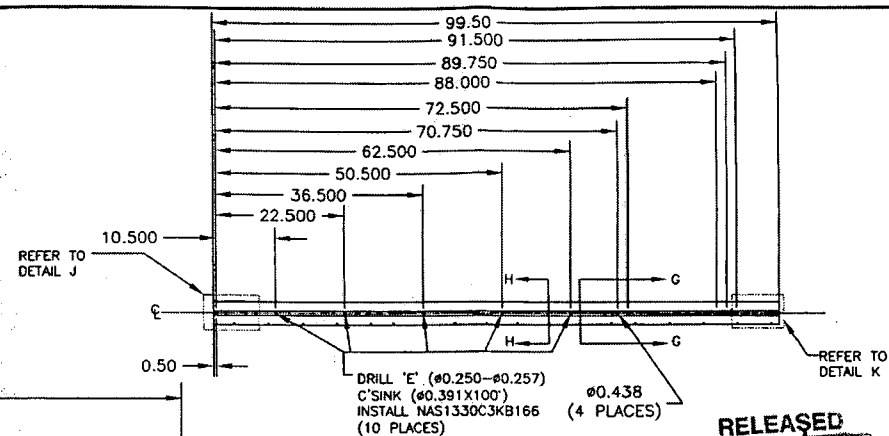
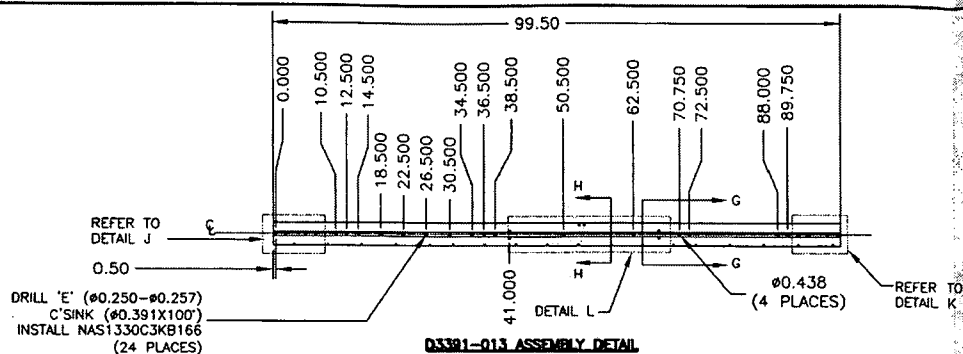
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X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

STOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
20425

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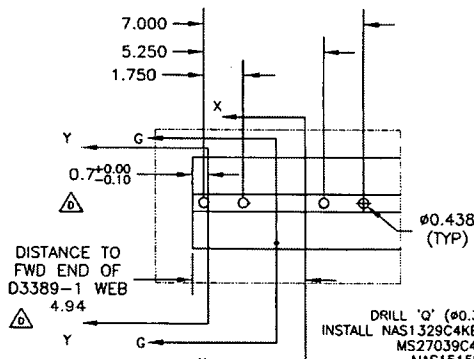
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DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC.
PH	PH		
CHECKED	APPROVED	DRAWING NO.	REV. D
		D3391	SHEET 2 OF 5
DATE		TITLE	SCALE
06.01.23		412 FLOAT SKIDTUBE	1:10

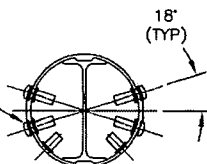
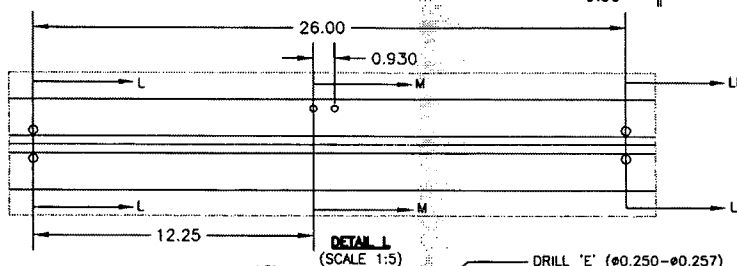


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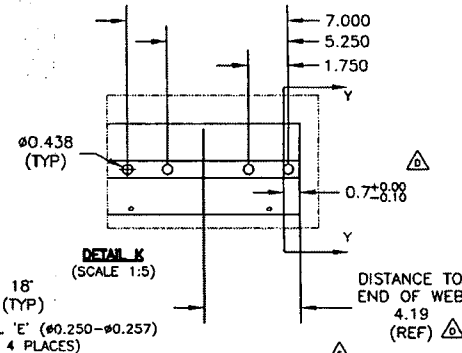
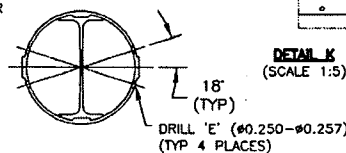
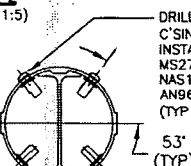
06 of 27



DRILL 'G' (#0.332-#0.338) INSTALL NAS1329C4KB140 INSERT MS27039C4-08 SCREW NAS1515H4L WASHER AN960C416L WASHER (TYP 4 PLACES)



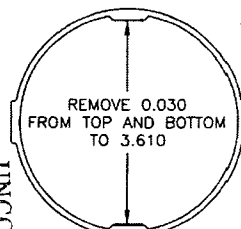
DRILL 'E' (#0.250-#0.257) C'SINK (#0.391X100) INSTALL NAS1330C3KB116 INSERT MS27039C1-09 SCREW NAS1515H3L WASHER AN960C10L WASHER (TYP 4 PLACES)



D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

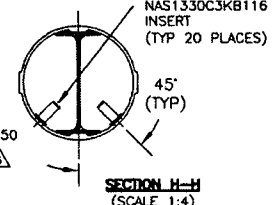
QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

SECTION I-I (SCALE 1:4)



REMOVE 0.225 FROM TOP AND BOTTOM TO 3.800 (0.7 FROM BOTH ENDS)

SECTION Y-Y (SCALE 1:4)

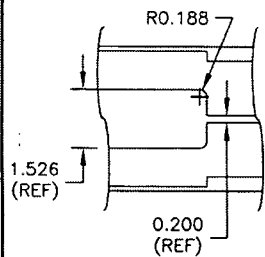


D3391-013/-023 MID TUBE ASSEMBLY

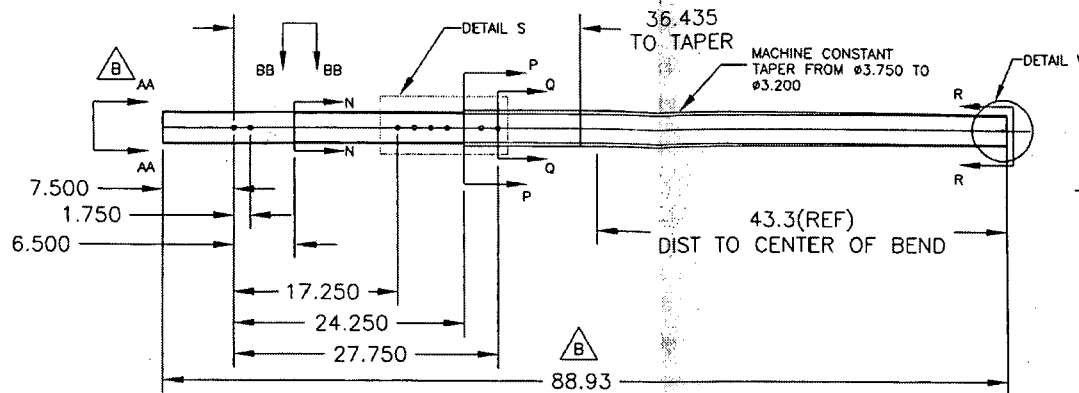
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER

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ENGINEERING
COPY
RETURN TO
WORK ORDER
20125

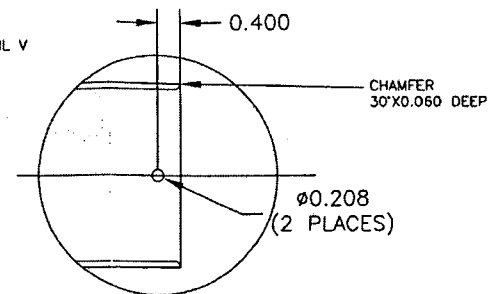
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DATE 06.01.23		DRAWING NO. D3391		REV. D
		TITLE 412 FLOAT SKIDTUBE		SHEET 3 OF 5
				SCALE 1:20



VIEW BB-BB
(SCALE 1:3)



D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

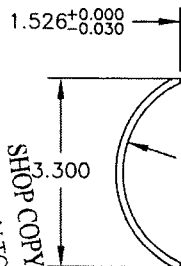


DETAIL V
(SCALE 1:2)

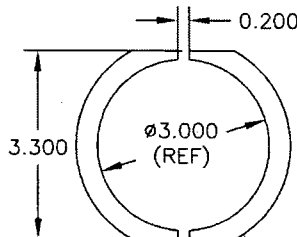
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06.01.23

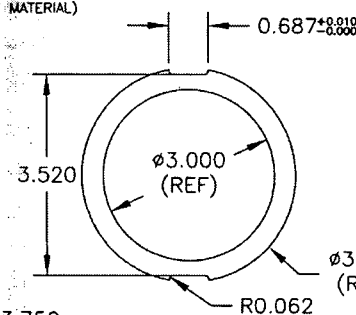
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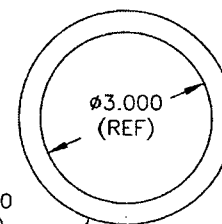
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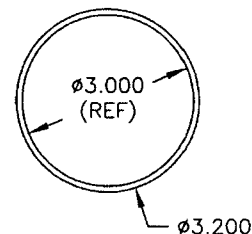
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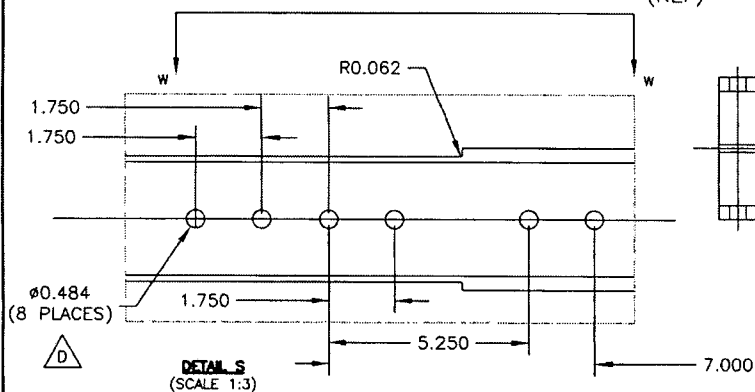
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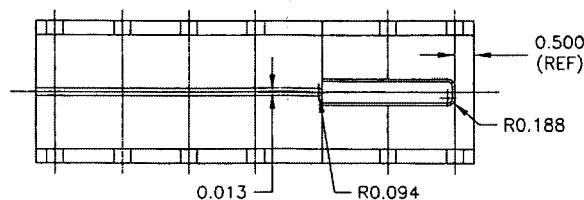
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



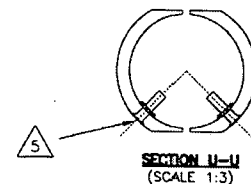
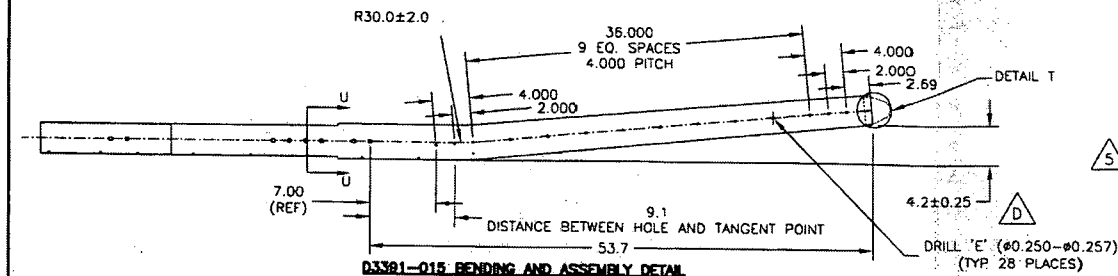
VIEW W-W
(SCALE 1:3)

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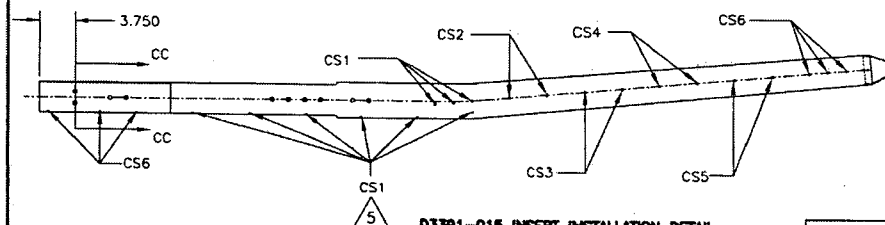
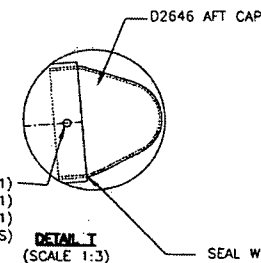
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DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT WILMINGTON, WA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3391
DATE	06.01.23	TITLE	412 FLOAT SKIDTUBE	REV. D SHEET 4 OF 5 SCALE 1:12

RELEASED
06.01.27

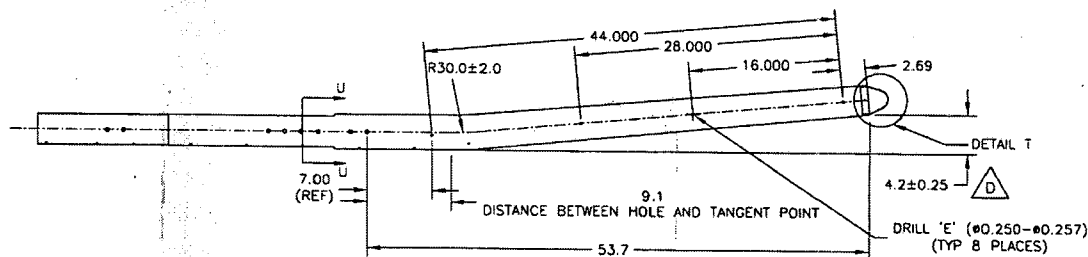


AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)



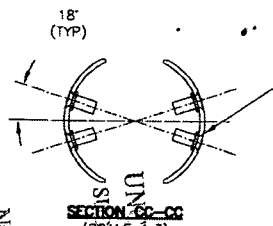
C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	4		Ø0.391	AESS10KB366
CS3	4	2	Ø0.391	NAS1330C3KB316
CS4	4	2	Ø0.391	NAS1330C3KB266
CS5	4		Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

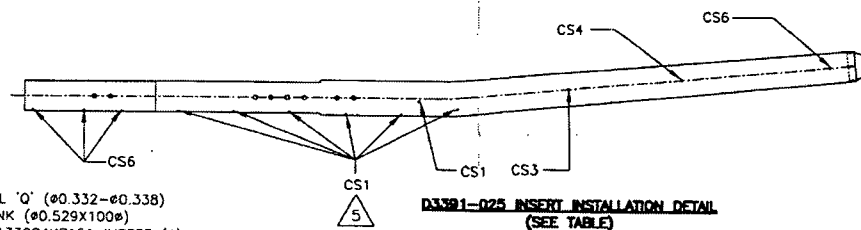


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4		NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



DRILL 'O' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100Ø)
NAS1330C4KB151 INSERT (1)
(4 PLACES)



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DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, OH
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3391
DATE 06.01.23	TITLE 412 FLOAT SKIDTUBE	REV. D SHEET 5 OF 5 SCALE 1:12

NO. 24125
WORK ORDER
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RETURN TO
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Peter Hum

From: David Shepherd [davids@dartaero.com]
Sent: Friday, April 21, 2006 10:59 AM
To: Peter Hum
Subject: Re: D3391-1 fwd tube tolerance update

The deviation on tolerance shown in your sketch is acceptable for current production and would be acceptable for future production with a drawing change and confirmation that production can work to these tolerances.

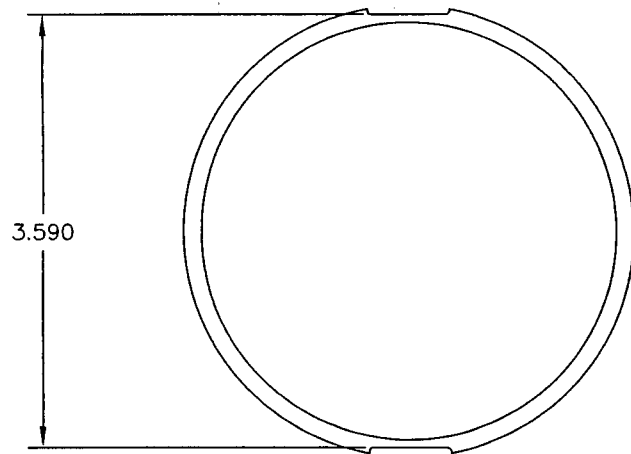
When you do the design review for the drawing change, ensure to include the sketch. I would suggest that we submit the updated dwg when we submit the drawings for the cable guard.

David

----- Original Message -----

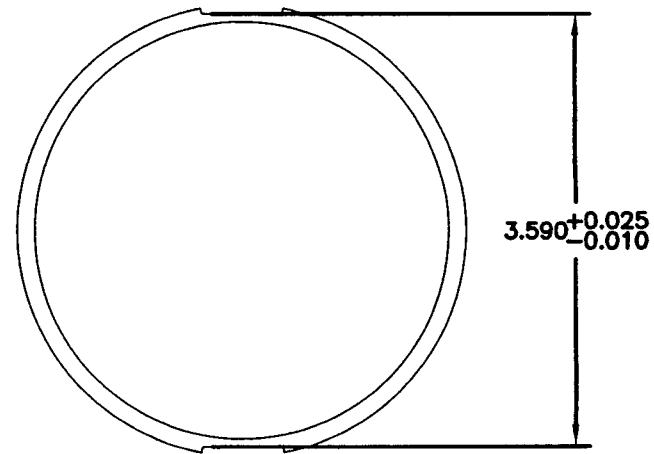
From: "Peter Hum" <phum@dartaero.com>
To: "David Shepherd (E-mail)" <davids@dartaero.com>
Sent: Wednesday, April 19, 2006 12:53 PM
Subject: D3391-1 fwd tube tolerance update

> David,
>
> I've attached a sketch (the proposed changes are in black),
>
> In machining the D3391-1 fwd tube, the dimensions of Section D-D and
Section
> C-C vary above/below the specified tolerance. In the majority of the cases
> the end result is more material and therefore an increase in strength.
>
> At the worst case tolerance (i.e. smallest area) the reduction in area is
> 0.5%. However in the critical section of the FWD tube, the ultimate margin
> of safety is 21%. Therefore, this reduction in area is very small compared
> to the overall margin of safety; therefore it will be acceptable.
>
> Can these deviations be applied to current and future production (will
> require drawing update)?
>
> Peter
>
>



3.590

NOMINAL DIMENSION

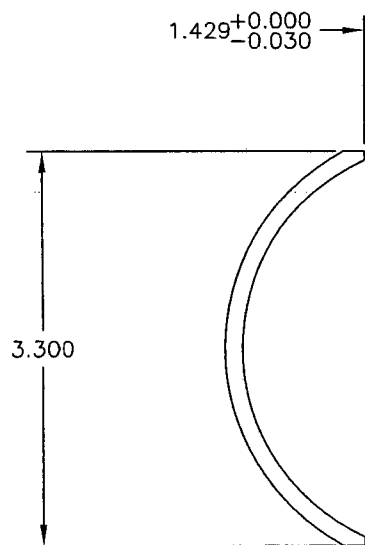


$3.590^{+0.025}_{-0.010}$

NEW DIMENSION/TOLERANCE

1) WORST CASE IS MORE MATERIAL

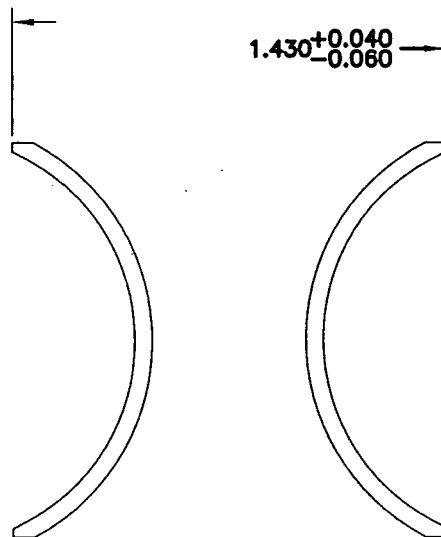
SECTION D-D



$1.429^{+0.000}_{-0.030}$

3.300

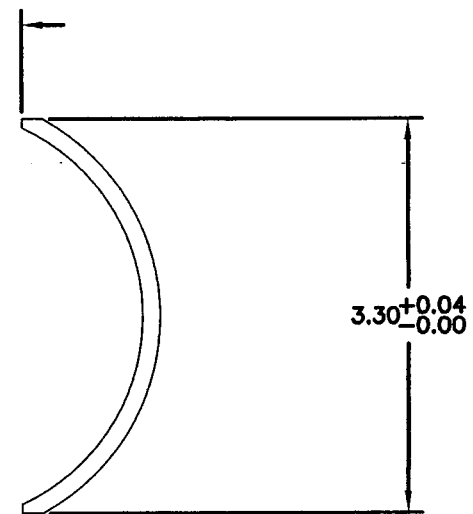
NOMINAL DIMENSION
AREA = 1.1853 IN²



$1.430^{+0.040}_{-0.060}$

NEW DIMENSION/TOLERANCE

MINIMUM AREA = 1.179 IN²



$3.30^{+0.04}_{-0.00}$

- 1) AT THE WORST CASE THE AREA IS REDUCED BY 0.5%
- 2) THE ULTIMATE MARGIN OF SAFETY OF THE CRITICAL SECTION IN THIS REGION OF THE SKIDTUBE IS 21%
- 3) THEREFORE, THIS REDUCTION WILL NOT BE A FACTOR

SECTION C-C

